

**AMENDMENTS TO THE CLAIMS**

1. (Currently Amended) An off-line feed rate scheduling method of a CNC machining process that is performed according to workpiece geometry and a given set of NC code provided from a CAD/CAM system, the method comprising:

selecting a constraint variable and inputting a reference value related to the constraint variable;

estimating a cutting configuration where a maximum constraint variable value (CVV) occurs through ME Z-map modeling;

obtaining the estimated cutting configuration and estimating a specific rotation angle ( $\varphi_s$ ) where the maximum constraint variable value occurs through constraint variable modeling;

calculating a feed rate that satisfies the reference value of related to the constraint variable at the estimated specific rotation angle; and

applying the calculated feed rate to the NC code.

2. (Original) The method of claim 1, wherein the calculating a feed rate comprises:

inputting specific feed rates  $f_1$  and  $f_2$  ( $f_1 < f_2$ );

calculating maximum constraint variable values  $CVV_1$  and  $CVV_2$  corresponding to the feed rates  $f_1$  and  $f_2$ , respectively, at the specific rotation angle;

approximating a feed rate  $f_{next}$  that corresponds to a reference value  $RV$  of a constraint variable value using the formula,

$$f_{next} = f_1 + \frac{(RV - CVV_1)(f_2 - f_1)}{CVV_2 - CVV_1};$$

calculating a constraint variable  $CVV_{next}$  in the case where the feed rate is  $f_{next}$ ; and

determining using the formula below if the constraint variable value  $CVV_{next}$  when compared to the reference value  $RV$  is less than an error limit, applying the feed rate  $f_{next}$  to the NC code when it is less than the error limit, replacing the feed rate  $f_2$  by  $f_{next}$  and repeating the process of obtaining  $f_{next}$  when this value is not less than the error limit and the reference value  $RV$  is greater than the constraint variable value  $CVV_{next}$ , and replacing the feed rate  $f_1$  by  $f_{next}$  and repeating the process of obtaining

$f_{next}$  when this value is not less than the error limit and the reference value is not greater than the constraint variable value  $CVV_{next}$ ,

where

$$\frac{CVV_{next} - RV}{RV} < \text{Error Limit}$$

3. (Currently Amended) The method of claim 1, wherein computing cutting configurations through ME Z-map modeling comprises:

- searching for node points located in a cutting area;
- identifying whether a target node is an edge node (~~a node closest to a cutter edge~~) or not;
- calculating and updating a height value of each node in the cutting area;
- moving a target node if it is an edge node and storing movement direction angles;
- computing the cutting configurations using the stored angles.

4. (Currently Amended) The method of claim 3, wherein the cutting configurations computed through ME Z-map modeling include at least one of an entry angle, an exit angle, and an axial depth of cut ~~and so on~~.

5. (Original) The method of claim 3, wherein in the case where a difference between a distance from a tool center to a target node and a tool radius is smaller than a movement limit, this node is designated as an edge node.

6. (Original) The method of claim 1, wherein one of cutting force and machined surface error is selected as a constraint variable.

7. (Currently Amended) An off-line feed rate scheduling method for adjusting a cutting force of a CNC machining process that is performed according to workpiece geometry and a given set of NC code instructing paths of a tool provided from a CAD/CAM system, the method comprising:

- inputting a reference cutting force;
- estimating a cutting configuration where a maximum cutting force occurs through ME Z-map modeling;
- receiving the estimated cutting configuration and estimating a specific rotation angle where the maximum cutting force occurs through cutting force modeling;
- calculating a feed rate that satisfies the reference cutting force at the estimated specific rotation angle; and
- applying the calculated feed rate to the NC code.

8. (Currently Amended) The method of claim 7, wherein the reference cutting force is selected from a reference cutting force  $RF_1$  established to prevent breaking of a tool shank, and a reference cutting force  $RF_2$  established to prevent damage to an edge portion of a tool,  $RF_1$  and  $RF_2$  being calculated by the formulae

$$RF_1 = SF \cdot TRS \cdot S_1$$

$$RF_2 = SF \cdot TRS \cdot S_2$$

where  $RF_1$  represents the reference cutting force considered to avoid breakage of tool shank and  $RF_2$  indicates the reference cutting force to prevent breakage of tool edge;  $SF$  means safety factor, which is used to make up for unpredictable factors such as cutter geometry error or cutter material variation; and  $TRS$  means transverse rupture strength of the a tool material.

9. (Currently Amended) The method of claim 7, wherein the tool is a flat end milling tool, and cutting force components of each axial direction of three-dimensional Cartesian coordinate according to a rotational angle of the tool are obtained using

$$F_x(j) = \sum_k \sum_i F_x(i, j, k)$$

$$F_y(j) = \sum_k \sum_i F_y(i, j, k)$$

$$F_z(j) = \sum_k \sum_i F_z(i, j, k)$$

where

$$F_x(i, j, k) = [C_1 K_n \cos(\phi - \alpha_r) + K_f K_n C_3 \cos \phi - K_f K_n C_4 \sin(\phi - \alpha_r)] t_c(\phi) B_1$$

$$F_y(i, j, k) = [C_1 K_n \sin(\phi - \alpha_r) + K_f K_n C_3 \sin \phi + K_f K_n C_4 \cos(\phi - \alpha_r)] t_c(\phi) B_1$$

$$F_z(i, j, k) = [-C_2 K_n + K_f K_n C_5] t_c(\phi) B_1$$

and where  $C_1, C_2, C_3, C_4$ , and  $C_5$  in the above are calculated by the following:

$$C_1 = \frac{\cos \theta_h}{\sin \theta_{th}}, \quad C_2 = \frac{\sin \theta_h}{\sin \theta_{th}} \cdot \cos \alpha_r$$

$$C_3 = \sin \theta_h (\sin \theta_c - \cos \theta_c \cot \theta_{th})$$

$$C_4 = \frac{\cos \theta_c}{\sin \theta_{th}}$$

$$C_5 = \cos \theta_h (\sin \theta_c - \cos \theta_c \cot \theta_{th})$$

and

$$\cos \theta_{th} = \sin \alpha_r \cdot \sin \theta_h$$

where i is a cutter tooth index, j is an index of a cutter rotation angle, k is an index of a z-axis disk element,  $\phi$  is an angle position of a cutter edge,  $\alpha_r$  is a rake angle,  $t_c(\phi)$  is uncut chip thickness,  $\theta_h$  is a helix angle,  $\theta_c$  is a chip flow angle, and  $K_n, K_f$ , and  $B_1$  are constants.

10. (Currently Amended) The method of claim 9, wherein  $K_n, K_f$ , and  $\theta_c$  may be obtained by the following formulae,

$$\ln(K_n(i, j, k)) = A_1 - (A_1 - A_2)e^{-(A_3 t_c(i, j, k))^{A_4}}$$

$$K_f(i, j, k) = B_1 - (B_1 - B_2)e^{-(B_3 t_c(i, j, k))^{B_4}}$$

$$\theta_c(i, j, k) = C_1 - (C_1 - C_2)e^{-(C_3 t_c(i, j, k))^{C_4}}$$

where  $A_1, A_2, A_3, A_4, B_1, B_2, B_3, B_4, C_1, C_2, C_3$ , and  $C_4$  are constants.

11. (Currently Amended) The method of claim 7, wherein the tool is a ball end milling tool, and cutting force components of each axial direction of three-

dimensional Cartesian coordinate according to a rotational angle of the tool are obtained using

$$\begin{bmatrix} F_x \\ F_y \\ F_z \end{bmatrix} = \begin{bmatrix} A_{11} & A_{12} & A_{13} \\ A_{21} & A_{22} & A_{23} \\ A_{31} & A_{32} & A_{33} \end{bmatrix} \begin{bmatrix} K_1 \\ K_2 \\ K_3 \end{bmatrix}$$

where

$$K_1 = K_n$$

$$K_2 = \cos \theta_c K_n K_f$$

$$K_3 = \sin \theta_c K_n K_f$$

$$A_{11} = B_1 \sum_k \sum_i (\cos \alpha_r, \cos \phi \cos \theta_h + \sin \alpha_r, \sin \phi) \cdot t_c(\phi)$$

$$A_{12} = B_1 \sum_k \sum_i (\sin \alpha_r, \frac{1}{f_2} \cos \phi \cos \theta_h - \frac{1}{f_2} \cos \alpha_r, \sin \phi - \frac{f_1}{f_2} \cos \alpha_r, \cos \phi \sin \theta_h) \cdot t_c(\phi)$$

$$A_{13} = B_1 \sum_k \sum_i (-\frac{f_1}{f_2} \sin \phi + \frac{1}{f_2} \cos \phi \sin \theta_h) \cdot t_c(\phi)$$

$$A_{21} = B_1 \sum_k \sum_i (\cos \alpha_r, \sin \phi \cos \theta_h - \sin \alpha_r, \cos \phi) \cdot t_c(\phi)$$

$$A_{22} = B_1 \sum_k \sum_i (\sin \alpha_r, \frac{1}{f_2} \sin \phi \cos \theta_h + \frac{1}{f_2} \cos \alpha_r, \cos \phi - \frac{f_1}{f_2} \cos \alpha_r, \sin \phi \sin \theta_h) \cdot t_c(\phi)$$

$$A_{23} = B_1 \sum_k \sum_i (\frac{f_1}{f_2} \cos \phi + \frac{1}{f_2} \sin \phi \sin \theta_h) \cdot t_c(\phi)$$

$$A_{31} = B_1 \sum_k \sum_i (-\sin \theta_h \cos \alpha_r) \cdot t_c(\phi)$$

$$A_{32} = B_1 \sum_k \sum_i (-\sin \alpha_r, \frac{1}{f_2} \sin \theta_h - \frac{f_1}{f_2} \cos \alpha_r, \cos \theta_h) \cdot t_c(\phi)$$

where i is a cutter tooth index, j is an index of a cutter rotation angle, k is an index of a z-axis disk element,  $\varphi$  is an angle position of a cutter edge,  $\alpha_r$  is a rake angle,  $t_c(\varphi)$  is uncut chip thickness,  $\theta_h$  is a helix angle,  $\theta_c$  is a chip flow angle, and  $K_n$ ,  $K_f$ ,  $B_1$ ,  $f_1$  and  $f_2$  are constants.

12. (Currently Amended) The method of claim 11, wherein  $K_n$ ,  $K_f$ , and  $\theta_c$  may be obtained by the following formulae:

$$K_n = K_1$$
$$\theta_c = \tan^{-1}\left(\frac{K_3}{K_2}\right)$$
$$K_f = \frac{K_2}{\cos\theta_c K_n}$$

where  $K_1$ ,  $K_2$  and  $K_3$  are constants.

13. (Original) An off-line feed rate scheduling method for adjusting a machined surface error of a CNC machining process that is performed according to workpiece geometry and a given set of NC code provided from a CAD/CAM system, the method comprising:

- inputting a reference surface error;
- estimating a cutting configuration where a maximum surface error occurs through ME Z-map modeling;
- receiving the estimated cutting configuration and estimating a specific rotation angle where the maximum surface error occurs through machined surface error modeling;
- calculating a feed rate that satisfies the reference surface error at the estimated specific rotation angle; and
- applying the calculated feed rate to the NC code.

14. (Original) The method of claim 13, wherein the tool is a flat end milling tool, and a cusp error  $C_h$  is calculated using the formula

$$C_h = R - \sqrt{R^2 - \left(\frac{f_t}{2}\right)^2}$$

where  $R$  is a tool radius and  $f_t$  is an edge feed rate.

15. (Currently Amended) The method of claim 13, wherein the tool is a ball end milling tool, and a cusp error  $C_h$  is calculated using the formula,

$$C_h = R - \sqrt{R^2 - \left(\frac{D}{2}\right)^2}$$

where  $D = \sqrt{(TPD^2 + f_t^2)}$ , TPD being an interval between a tool path, R being a tool radius and  $f_t$  being an edge feed rate.